



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5953 Job Sheet 189123



Part No: D5953

Job Qty: 6 pcs

Part Name: Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/18/19

Job Tracking No:

Due Date: 2/16/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:f ecn 826 06.12.06 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs		2/16/19	0.79	15.79	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL / VHS
							HAAS - 4		
110	QC 1	6 pcs		2/16/19	0.00	0.00	QC 1 - 14 QC2-23		VHS 19/4/16
							QC 1 - 35		
							QC 1 - 8		
							QC 1 - 9		
120	QC 8	6 pcs		2/16/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
130	Handfinish - 1-1 Chemical-	6		2/16/19	0.00	0.00	Handfinish - 1 - 1 -		



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S170066



Part: D5953

Job No: 189123

Serial No/Batch: S170066

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/05/19

B4B

pcs

140 Powdercoat - 1 White Gl(A)- 6 2/16/19 0.00 0.28
 B4B *M151749* pcs

START: 7:50 O.V.T. 30 FINISH: 8:20*

150 QC 3 6 2/16/19 0.00 0.00
 pcs

B4B	
Handfinish - 1 - 2 - B4B	
Handfinish - 1 - 3 - B4B	
Handfinish - 1 - 4 - B4B	
Handfinish - 1 - 5 - B4B	
Handfinish - 1 - 6 - B4B	
Handfinish - 1 - 7 - B4B	
Handfinish - 1 - 8 - B4B	
Handfinish - 1 - 9 - B4B	
Handfinish - 1 - 10 - B4B	<i>D.R.19/04/09</i>
Handfinish - 1 - 11 - B4B	
Handfinish - 1 - 12 - B4B	
Handfinish - 1 - 13 - B4B	
Handfinish - 1 - 14 - B4B	
Handfinish - 1 - 15 - B4B	
Handfinish - 1 - 16 - B4B	
Handfinish - 1 - 17 - B4B	
Handfinish - 1 - 18 - B4B	
Handfinish - 1 - 19 - B4B	
Handfinish - 1 - 20 - B4B	
Handfinish - 1 - 21 - B4B	
Handfinish - 1 - 22 - B4B	
Powdercoat - 1 - B4B	
Powdercoat - 2 - B4B	
Powdercoat - 3 - B4B	<i>BR 19-04-10</i>
Powdercoat - 4 - B4B	
QC 3 - 10	
QC 3 - 13	
QC 3 - 15	
QC 3 - 17	
QC 3 - 18	
QC 3 - 2	
QC 3 - 26	
QC 3 - 28	
QC 3 - 3	
QC 3 - 30	
QC 3 - 34	
QC 3 - 36	
QC 3 - 38	
QC 3 - 41	
QC 3 - 51	
QC 3 - 58	

					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	DAS 40
					QC 3 - 9	APR 10 2019 9-89
160	Packaging 3-1 - Stock - B4B	6	2/16/19	0.00	0.00	Packaging 3 - 1 - B4B
	pcs					Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 - B4B
						Packaging 3 - 13 - B4B
						Packaging 3 - 14 - B4B
						Packaging 3 - 15 - B4B
						Packaging 3 - 16 - B4B
						Packaging 3 - 17 - B4B
						Packaging 3 - 18 - B4B
						Packaging 3 - 19 - B4B
						Packaging 3 - 20 - B4B
						Packaging 3 - 21 - B4B
						Packaging 3 - 22 - B4B
						Packaging 3 - 23 - B4B
						Packaging 3 - 24 - B4B
						Packaging 3 - 25 - B4B
						Packaging 3 - 26 - B4B
						Packaging 3 - 27 - B4B
						Packaging 3 - 28 - B4B
						Packaging 3 - 29 - B4B
						Packaging 3 - 30 - B4B
						Packaging 3 - 31 - B4B
						Packaging 3 - 32 - B4B
						Packaging 3 - 33 - B4B
						Packaging 3 - 34 - B4B
						Packaging 3 - 35 - B4B
						Packaging 3 - 36 - B4B
170	QC 21 - SA	6	2/16/19	0.00	0.00	QC 21 - SA - 21
	pcs					QC 21 - SA - 70

Part Op 100 - (HAAS CNC Vertical Machine), 1-Machine as per folio D5953, Ensure Batch Number is entered
 Descriptions: 110 - (QC1- Inspection performed by CMM), Inspect on CMM as per folio CMMA017.
 120 - (QC8- Inspect parts - second check)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), START TIME: _____
 150 - (QC3- Inspect Part Finish)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	6 pcs (1 ea)	100-HAAS 4 Axis	5X 5147787 1X 5166702

Job Allocations

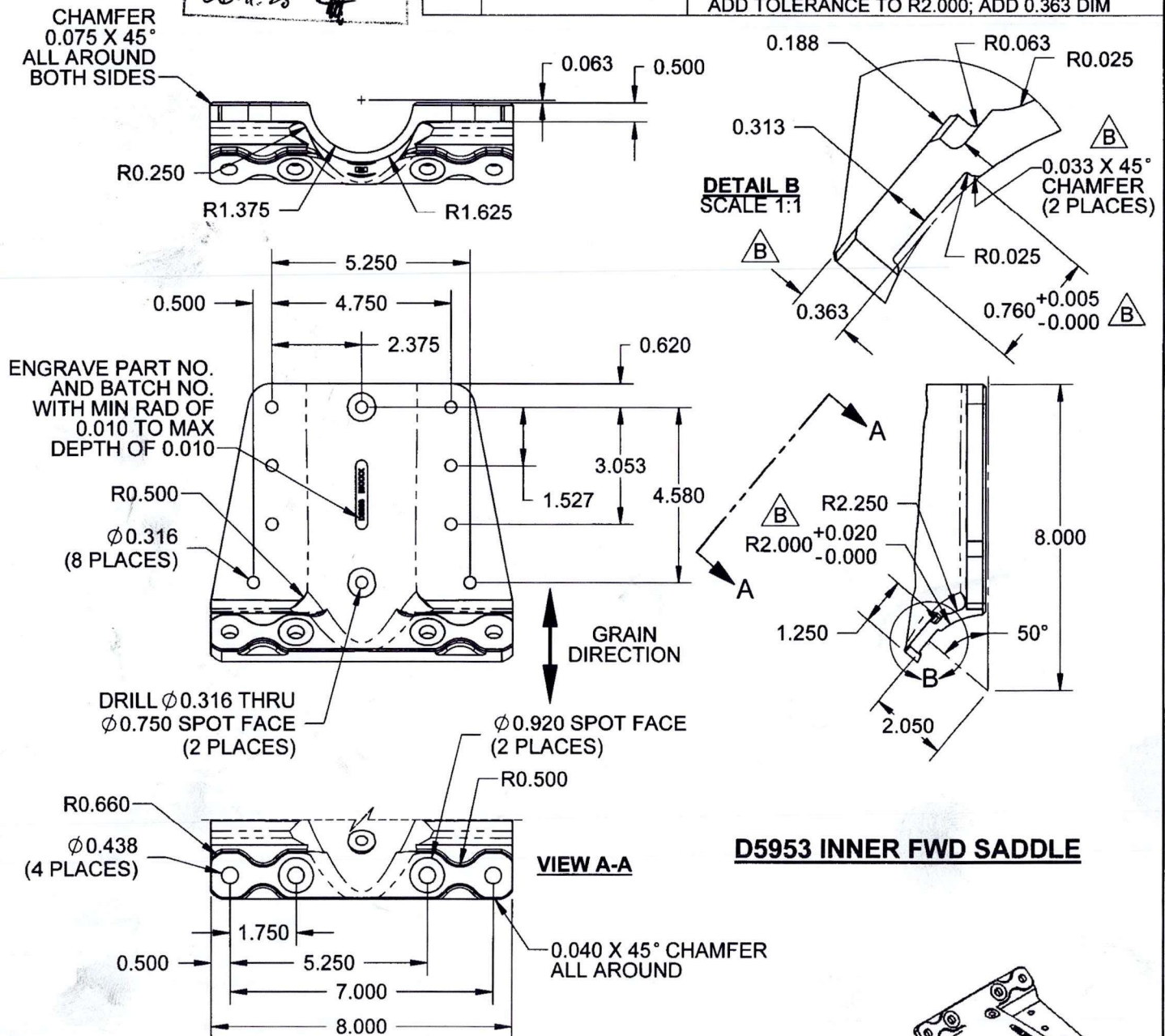
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-007	6	9	0

Part Specifications
Specifications could not be found.

Plex 1/18/19 11:42 AM Dart.Macdonald.Dara

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5953	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER FWD SADDLE SCALE 1:4		
REV	DATE	DESCRIPTION	
A	97.05.06	NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 189 123
Description: Inner Fwd Saddle		Part Number: D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.760		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.316	0.316	0.316	0.316		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.316	0.316	0.316	0.316		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.501	0.500	0.500	0.499		
N	1.615	1.635		1.628	1.628	1.628	1.628		
O	7.990	8.010		7.998	8.000	8.000	7.999		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.312	0.312	0.312	0.312		
R	0.760	0.765		0.761	0.761	0.761	0.761		
S	0.490	0.510		0.500	0.496	0.497	0.498		
T	1.375	1.395		1.376	1.376	1.376	1.376		
U	2.000	2.020		2.001	2.001	2.001	2.001		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	57 DAS
Date:	9-89 19/04/06

Audited by:	angie
Date:	19/04/08

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	

DART AEROSPACE LTD		Work Order:	
Description: Inner Fwd Saddle		Part Number:	D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		5.250	5.250				
F ✓	4.745	4.755		4.750	4.750				
G ✓	0.315	0.322		0.316	0.316				
H ✓	1.522	1.532		1.527	1.527				
I ✓	3.048	3.058		3.053	3.053				
J ✓	4.575	4.585		4.580	4.580				
K ✓	0.315	0.322		0.316	0.316				
L ✓	0.495	0.505		0.500	0.500				
M	0.490	0.510		0.500	0.498				
N ✓	1.615	1.635		1.628	1.628				
O	7.990	8.010		7.999	8.000				
P ✓	2.240	2.260		2.250	2.250				
Q	0.307	0.312		0.312	0.312				
R ✓	0.760	0.765		0.761	0.761				
S	0.490	0.510		0.500	0.489				
T ✓	1.375	1.395		1.376	1.376				
U ✓	2.000	2.020		2.001	2.001				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	19/4/16

Audited by:	<i>[Signature]</i>
Date:	19/04/16

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	<i>[Signature]</i>